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IS 4768 (1968): Stainless Steel Buckets [MED 33: Utensils, Cutlery and Domestic Hardware]

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(Reaffirmed 2002)

Indian Standard

SPECIFICATION FOR STAINLESS STEEL BUCKETS

(First Revision)

Utensils Sectional Committee, CPDC 5 [Ref : Doc: CPDC 5 (1427)]

1. **Scope** — Covers the requirements for stainless steel buckets.

2. **Material** — The material shall conform to Designation X04Cr18Ni11 or X07Cr18Ni9 of IS : 5522-1978 'Specification for stainless steel sheets and coils (*first revision*)'.

2.1 The thickness of the sheet and diameter of the stainless steel bar for the handle shall be as given below:

Part of the Bucket	*Nominal Size* of the Bucket*	*Thickness/Diameter*
	mm	mm
Body and Bottom	225 and 250	0·710
	275 and 300	0·800
	325 and 350	0·900
Bottom ring	225 and 250	1·25
	275, 300, 325 and 350	1·60
Ears	225, 250, 275, 300, 325 and 350	1·25
Handle	225 and 250	6
	275 and 300	8
	325 and 350	10

*Diameter of the bucket at the top.

2.2 In case the rim of the body is wired, the wire shall be made of stainless steel.

2.3 A deviation of maximum 15 percent shall be permitted for negative tolerance on sheet thickness and the reduction in drawing due to forming process.

3. **Dimensions** — Shall be as given in Fig. 1.

4. **Workmanship and Finish** — Body and the bottom of the bucket shall be either pressed or be of all welded construction. Bottom shall be dished. The bottom ring shall be spot-welded to the body at four to six places in pairs, equally spaced on the periphery of the body. The rim of the body shall be uniformly beaded. If agreed to between the purchaser and the supplier, the rim shall also be wired before beading. The ears shall be diametrically opposite to each other. All welds shall be sound. The handle curvature shall be such as to correspond with the rim of the bucket.

4.1 *Finish* — The buckets shall have no sharp or open edges and shall be given a mirror finish. When specifically required by the purchaser, they shall be given a satin finish on the inside. The buckets shall be free from distortion, dents, wrinkles, wavy surface, burrs, scratches, pittings, deep tool marks and other surface defects which affect the sterilization requirements for medical use.

5. **Performance Test** — The bucket shall be filled with water to the brim and kept for 15 minutes. The bucket shall not show any sign of leakage during this period.

5.1 A water tank of suitable size full of water shall be used for conducting the test. The dry empty bucket with its top facing upwards shall be pressed down the water vertically taking care that the top is at least 6 mm above the water level. It shall be observed whether any water gets into the bucket from the bottom or sides of the bucket. If any water enters the bucket, it shall be considered to have failed in the test. The bucket shall be withdrawn, reversed (with top downwards) and again pressed down the water vertically without agitating the water. Should any air bubble be seen escaping through the water, the bucket shall be deemed to leak and, therefore, shall be considered to have failed in the test.

Adopted 25 February 1981

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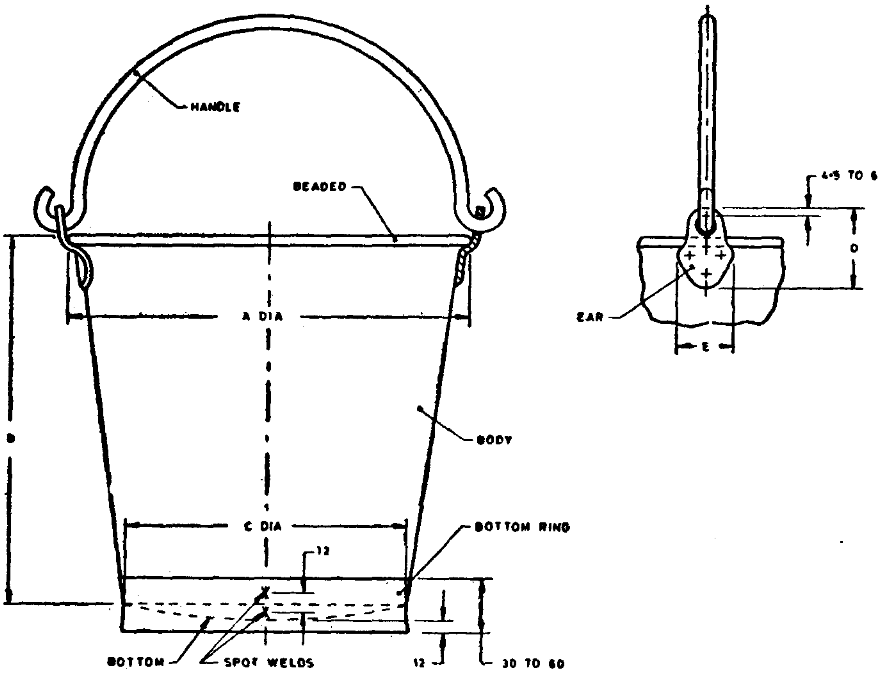

Nominal Size	*Body			*Ear		†Nominal Capacity in Litres
	Top Dia	Depth	Bottom Dia	Height	Width	
	A	*B*	*C*	*D*	*E*	
225	225	200	150	55	35	5·5
250	250	225	170	55	35	8·0
275	275	250	190	63	40	11·0
300	300	275	210	63	40	14·0
325	325	300	230	63	40	18·0
350	350	325	250	63	40	23·0

*General tolerance on the body = 5 and on the ear = 3.

†The capacity shall be calculated when the bucket is full to the brim.

All dimensions in millimetres.

FIG. 1 STAINLESS STEEL BUCKET

6. Marking — Each bucket shall be suitably marked at the bottom with the manufacturer's name, registered trade-mark or identification mark and the nominal capacity. The impression shall not show up on the inside.

6.1 *Certification Marking* — Details available with the Bureau of Indian Standards.

7. Packing — The bucket shall be wrapped in soft tissue paper and packed in accordance with the instructions of the purchaser. Care shall be taken to see that the buckets do not get scratched, deformed or dented during transit.

EXPLANATORY NOTE

This standard was first printed in 1978. In the revised standard material designation conforming to latest standard has been covered. Remaining clauses have been reworded suitably and nominal capacity has been added in marking clause.

Reprography Unit, BIS, New Delhi, India